

Date: Tuesday, 13/01/2009 4:07:34 PM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG
Job Number	: 44737		
Estimate Number	: 13367		
P.O. Number	:	Part Number	: D358913
This Issue	: 13/01/2009 S.O. No. :	Drawing Number	: D3589 REV B PRELIM
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: B PRELIM
Previous Run	: 40369	Material	:
Written By	:	Due Date	: 15/01/2009 Qty: 2 Um: Each
Checked & Approved By	: <u>mf 09-1-13</u>		
Comment	: Est Rev:A 08-05-30 new issue DD verified by:ec		











Additional Product

PRELIMINARY ISSUE

Job Number:



209.01.14 Rea EWN 408-502P

Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 Sheet .063
 		
Comment: Qty.: 0.0049 sf(s)/Unit Total : 0.0099 sf(s) 304/316 .063 Sheet batch: <u>109057</u> <u>B 9-1-15</u>		
2.0	WATER JET	FLOW WATER JET
 		
Comment: FLOW WATER JET 1-Cut as per Dwg D3589 Dwg Rev: <u>PRE</u> Prog Rev: <u>Lim</u> <u>B 9-1-15</u>		
2-Deburr if necessary <u>B 9-1-15</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
 		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
 		
Comment: SECOND CHECK <u>209.01.15</u> (2)		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
 		
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		
<u>209/01/16</u> (2)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: LUG

Job Number: 44737

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/17 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-16

POSITIVE RECALL

EFFECTIVE 09.01.14 AUTH *[Signature]*

RELEASED *[Signature]* DATE 09.02.17

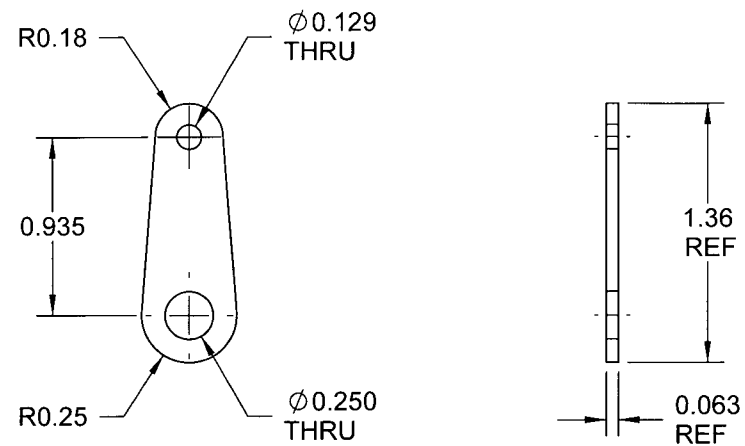
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

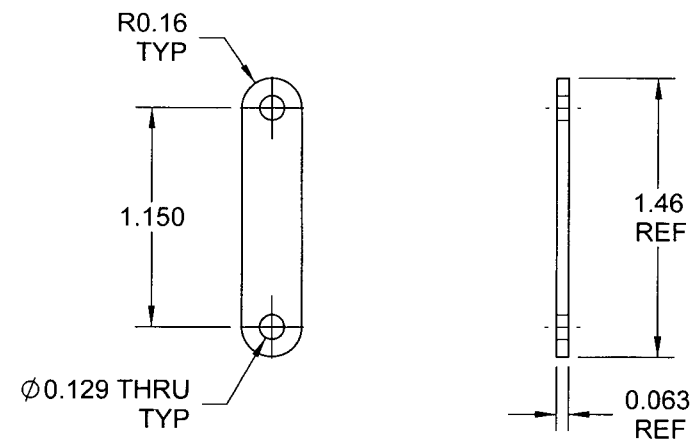
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3589-13 LUG



D3589-15 LINK

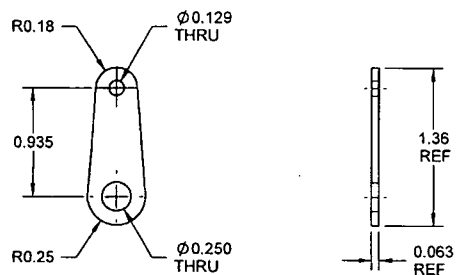
D3589-13/-15 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524,
OR MIL-S-5059 (ANNEALED) 2B FINISH
16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs EACH

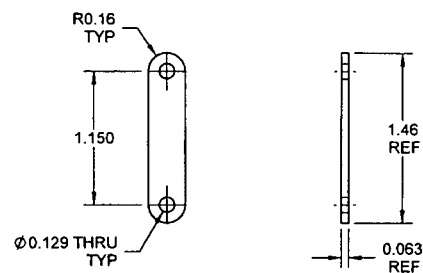
PRELIMINARY ISSUE

44737
Per ECN#09-502P
09.01.14

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3589	SHEET 7 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		LATCH ASSEMBLY	NTS
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D3589-13 LUG








D3589-15 LINK

44737

RELEASED
08/02/05

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